

**Work Order ID 84887**

May-29-12 1:34:02 PM

**\*84887\***

Page 1

Item ID: D209-669-013

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***Start Date: 29/05/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/05/30 Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	<u>XSP</u>
D209-669-013	Rev B	
DSI 9450	Rev A	

100  
**\*100\*** DOCUMENT CONTROL  
DC  
Document Control      Memo  
Photocopy bluefile & type labels per PPP d209-669-013 CHG003  
per \$12.599 W

0.00      100      12/05/12  
0.00      16      004

for MLJ 12-7-11

110      Pick Kit      0.00

**\*110\***  
Packaging      Memo  
Packaging      0.00

SP  
12-7-11

84931

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description SI Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID** 84887

May-29-12 1:34:02 PM

\*84887\*

Page 2

Item ID: D209-669-013

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop

\*NS2\*

Start Date: 29/05/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC4- 100% Inspect kits for completeness

\*120\*

QC

Quality Control

0.00  
  
 12/07/12

130

\*130\*

Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-013  
Location: 

12/11/12 O

140

\*140\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/11/12 D

MF  
12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

May-29-12 1:02:57 PM

Page 1

Work Order ID: 84887

\*84887\*  
\*D209-669-013\*

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: New IPP 08.02.13 LL, verified by:DD  
IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D209-669-043  
**\*D209-669-043\***  
Replacement Skidtube

Location	Loc Qty	Loc Code
----------	---------	----------

Mezz	2	
39205	1	
39206	1	

D2917-1  
**\*D2917-1\***  
Saddle LH

110	Each	0.0000	2	2
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\*\*

84931

D2918-1  
**\*D2918-1\***  
Saddle LH

110	Each	3.0000	2	2
-----	------	--------	---	---

\*\*

B84937 SP SP

AN4-51A  
**\*AN4-51A\***  
Bolt

ST424	3	
54467	3	

110	Each	302.0000	8	8
-----	------	----------	---	---

\*\*

SP 10-7-11 SP

Location	Loc Qty	Loc Code
----------	---------	----------

362	200	
121181	200	
ST361	102	
119798	30	
121584	72	

8x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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May-29-12 1:02:57 PM

Page 2

Work Order ID: 84887

**\*84887\***

Parent Item: D209-669-013

**\*D209-669-013\***

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2570

Manufactured No

110

Each

711.0000

24

24

\*\*

**\*D2570\***

Bushing

*B85411 SP.*Location      Loc Qty      Loc Code

ST011	711	
72960	41	
78586	9	
79493	12	
81956	24	
81957	400	
82874	225	

MS21042L4

Purchased No

110

Each

4,095.000

24

24

\*\*

**\*MS21042L4\***

Nut

*SP SP*Location      Loc Qty      Loc Code

ST300	4095	
119075	125	
121011	713	
121444	2957	
<u>121652</u>	300	

AN5-36A

Purchased No

110

Each

184.0000

4

\*\*

**\*AN5-36A\***

Bolt

*TX TX SP SP*Location      Loc Qty      Loc Code

340	134	
121181	34	
<u>121652</u>	100	
ST340	50	
121708	50	

AN960JD516

NAS1149D0563J Purchased

No

110

Each

0.0000

8

\*\*

**\*AN960JD516\***

Washer

*M119546 SP**12-7-11*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 84887

\*84887\*

Parent Item: D209-669-013

\*D209-669-013\*

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

1,447.000

4

4

\*\*

\*MS21042L5\*

Nut

SP.

SP.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
300	500	
121652	500	
ST300	947	
108827	8	
116105	5	
116548	43	
117611	18	
119109	865	
17651	8	

AN4-7A

Purchased

No

110

Each

124.0000

16

16

\*\*

\*AN4-7A\*

Bolt

m/22/4/SP

SP.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST356	124	
117514	24	
120770	100	

AN960JD416

NAS1149D0463J Purchased

No

110

Each

30.0000

32

32

\*\*

\*AN960JD416\*

Washer

m/21/9/2 SP.

SP.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	30	
116289	10	
119097	20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 84887

\*84887\*  
\*D209-669-013\*

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2929

\*D2929\*

Spacer

Manufactured No 110 Each 86.0000 2 2 \*\*

SP SP

D2930

\*D2930\*

Spacer

Manufactured No 110 Each 102.0000 2 2 \*\*

2x 2 SP SP

D3405-041

\*D3405-041\*

Lug Assembly

Manufactured No 110 Each 6.0000 1 1 \*\*

2x 1 B83896 SP SP

AN4C47A

\*AN4C47A\*

Bolt

Purchased No 110 Each 48.0000 4 4 \*\*

m122204 SP  
12-7-11

Location	Loc Qty	Loc Code
ST361	48	
118451	6	
119798	2	
121009	22	
121585	18	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

May-29-12 1:02:57 PM

Page 5

**Work Order ID:** 84887**\*84887\*****Parent Item:** D209-669-013**\*D209-669-013\*****Parent Item Name:** Skidtube LH**Start Date:** 29/05/2012**Required Date:** 16/07/2012**Start Qty:** 1.00**Required Qty:** 1.00

MS21043-4

Purchased No 110 Each 1,346.000 5 5

**\*\*****\*MS21043-4\***  
Nut

Sp. 1/1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
104603	40	
ST301	1306	
119546	147	
121162	659	
121652	500	

D3405-043

Manufactured No 110 Each 2.0000 1 1

**\*\*****\*D3405-043\***  
Lug Assembly

B83897 SP 1/1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST478	2	
82038	2	

D3407-041

Manufactured No 110 Each 27.0000 1 1

**\*\*****\*D3407-041\***  
Tow Ring

B85444 12-7165

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST463	27	
82067	6	
82068	19	
82108	2	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

May-29-12 1:02:57 PM

Page 6

Work Order ID: 84887

**\*84887\***  
**\*D209-669-013\***

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

156.0000

1

1

\*\*

**\*D3456-1\***  
WasherLocation      Loc Qty      Loc Code

FG	7	
25701	7	
ST044	149	
80252	1	
81876	48	
83584	100	

D3417-5

Manufactured No

110

Each

78.0000

2

2

\*\*

**\*D3417-5\***  
WasherLocation      Loc Qty      Loc Code

ST042	78	
78842	28	
83318	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

## **INSTRUCTIONS:**

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84887 MUJ  
12/05/30

A	NEW ISSUE		AJS	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9450	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		SKIDTUBE INSTALLATIONS	NTS	
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## 5.0 PARTS LIST

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
1	1				X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
		1	1			X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)

IS:

50	4	4	1	1		D3405-041	LUG ASSEMBLY
51	8	8	4	4		AN4C47A	BOLT
52	16	16	8	8		D2570	BUSHING
53	8	8	4	4		MS21043-4	NUT
54			1	1		D3405-043	LUG ASSEMBLY
60	1	1	1	1		D3407-041	TOW RING ASSEMBLY
61	1	1	1	1		D3456-1	WASHER
62	1	1	1	1		MS21043-4	NUT
63	2	2	2	2		D3417-5	WASHER

WAS:

50	4	4	1	1		D2736-1	GHW LUG
51	8	8	4	4		AN4-46A	BOLT
52	16	16	8	8		D2570	BUSHING
53	8	8	4	4		MS21042L4	NUT (OR MS21042-4)
54			1	1		D2736-3	GHW LUG
60	1	1	1	1		D2968-041	TOW RING
61	1	1	1	1		AN970-4	WASHER
62	1	1	1	1		MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 2 OF 3
APPROVED	JAY	TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

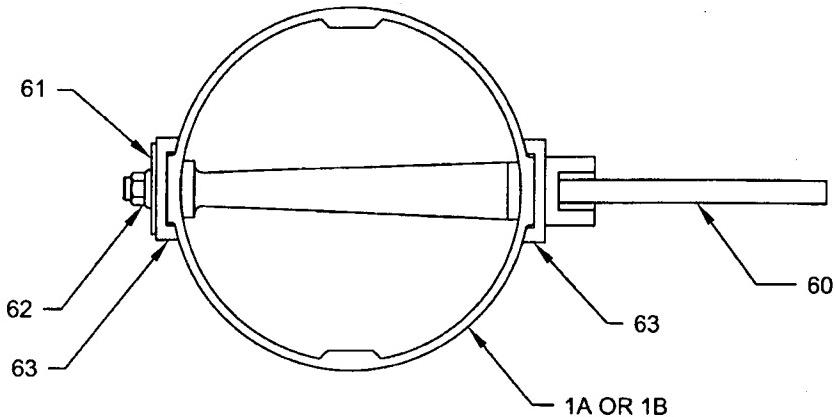
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
•	•							

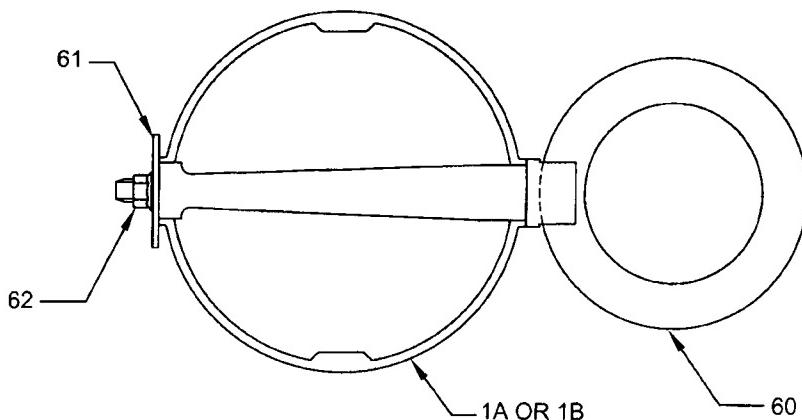
NOTE: Date &amp; initial all entries

INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

**IS:**



**WAS:**



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED	MJ	TITLE	SCALE
DE APPR.	H	SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

X88100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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